IN THE CLAIMS

Please amend claims 1, 5-7 and 10 as follows:

1. (*Currently Amended*) A process for forming a metal cylindrical bearing roller, said process consisting of the steps of:

obtaining a hardened metal cylindrical blank having end face surfaces, a lateral surface defining an outer diameter, and a centered circular bore, said bore having an inner surface defining an inner diameter;

~~hard turning~~ honing the inner surface of the bore having a specified inner diameter, thereby forming an inner bearing surface;

hard turning the lateral surface of the blank to a specified outer diameter, thereby forming an outer bearing surface concentric with said inner bearing surface; and

thereby forming a metal cylindrical bearing roller.

2. (*Previously Amended*) The process of claim 1 wherein said hard turning the lateral surface of the blank further includes forming a radial crown.

3. (*Original*) The process of claim 1 wherein said blank is made of a steel material and is formed by a method selected form the group consisting of warm forging, hot forging, cold forming, and machining.

4. (*Original*) The process of claim 3 wherein said formed blank is heat treated.

5. (*Currently Amended*) The process of claim 1 wherein said blank is cold formed and comprises a pierced flash, said process further comprising:

prior to ~~hard turning~~ honing said inner surface of said bore to a specified inner diameter, removing said pierced flash.

6. (*Currently Amended*) The process of claim 5 wherein said removing said pierced flash is carried out by ~~hard turning~~ honing said inner surface of said bore.

7. (*Currently Amended*) The process of claim 1 wherein said ~~hard turning~~ honing of said inner surface of said bore is carried out using a diamond honing machine.

8. (*Original*) The process of claim 1 further comprising:

forming an incised cross-hatch pattern on said inner surface of said bore.

9. (*Previously Amended*) The process of claim 1 wherein said hard turning said lateral surface is carried out using a computer numerically controlled (CNC) lathe.

10. (*Currently Amended*) The process of claim 1 wherein said ~~hard turning~~ honing the inner surface of said bore precedes said hard turning the lateral surface of said blank.

11. (*Original*) The process of claim 1 wherein said hard turning the lateral surface of said blank precedes said hard turning the inner surface of said bore.

12. (*Previously Added*) The process of claim 9 wherein said lathe comprises a cubic boron nitride or ceramic cutting tool.

13. (*Previously Added*) The process of claim 1 wherein said hard turning the lateral surface of the blank is carried out in a single operation.

14. (*Previously Added*) The process of claim 1 wherein said end face surfaces of said cylindrical blank comprise end face surfaces of said cylindrical bearing roller.